

Date: Monday, 07/04/2008 2:30:09 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	COVER
Job Number :	38445		
Estimate Number :	10287		
P.O. Number :		Part Number :	D32021
This Issue :	07/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3202 REV B1
First Issue :	11	Project Number :	N/A
Previous Run :	35065	Drawing Revision :	B1
Written By :		Material :	
Checked & Approved By :	JLD 08.4.06	Due Date :	30/04/2008
Comment :	Est Rev:B No Longer Made In House	Qty:	20
	Est Rev:C Now on Waterjet	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S032	5052-H32 .032 Sheet
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Comment: Qty: 1.6286 sf(s)/Unit Total: 32.5710 sf(s)

5052-H32 .032 Sheet

Batch: 105988 IB 8-4-8

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3202

Dwg Rev: B1

Prog Rev: B1

IB 8-4-8



2-Deburr if necessary

IB 8-4-8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-4-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/04/08 H15

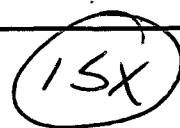
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H

08/04/09



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Drawing Name: COVER

Job Number: 38445

Part Number: D32021

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 POWDER COATING POWDER COATING



M 10 6442



(15X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-A 08/04/09

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



del



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-09

(X15)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 238 A

Po 8/4/10 (15)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/14 A

Comment: FINAL INSPECTION/W/O RELEASE







Job Completion



MF 08-04-10

h

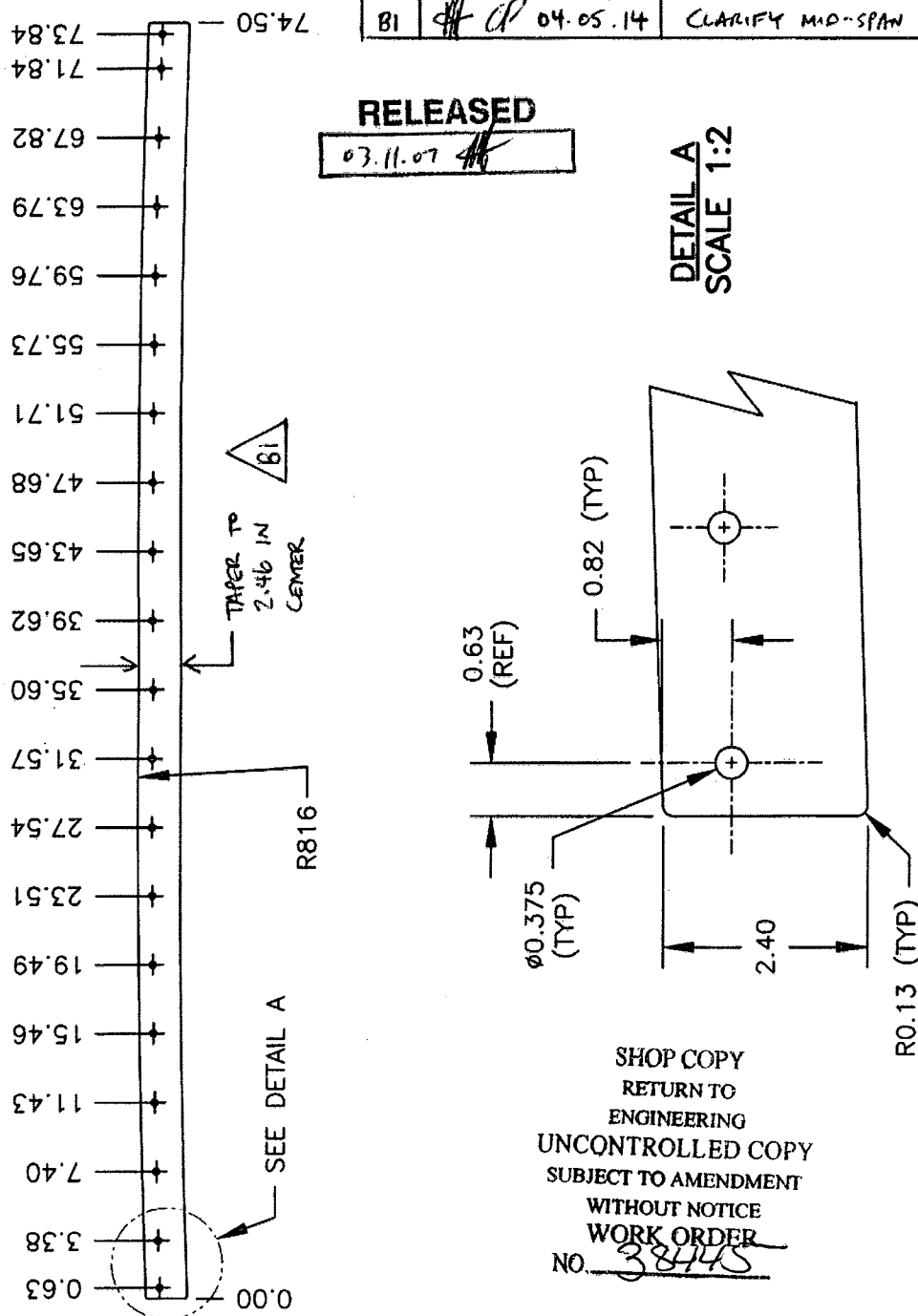


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3202	REV. B SHEET 1 OF 1
DATE 03.10.16		TITLE COVER	SCALE 1:10
A	01.01.01	NEW ISSUE	
B	03.10.16	REDESIGN; PART NOW CURVED	
BI	  04.05.14	CLARIFY MID-SPAN DIMENSION	

RELEASED

03.11.07 46

DETAIL A
SCALE 1:2



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38445

D3202-1 COVER

- 1) MATERIAL: 5052-H32/H34 SHEET (QQ-A-250/8) 0.032 THICK (REF DART SPEC. M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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